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TECHNICAL DATA SHEET

TERNALLOY 402

Brazing alloys, Cadmium Free

EN ISO 17672:2016 -
AWS A5.8-92 -
ISO 3677:1997
DIN 8513
(EN 1044:1999)

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
40	29,85	28	2	0,15	-	-

Technical Data

Melting Point	c.a. 650 - 710 °C
Working Temperature	c.a. 695 °C
Density	c.a. 9,1 gr/cm3-
Tensile strength	430 Mpa
Elongation	17%
Electrycal Conductivity	m/? mm²
Operating temp. of brazed joint	

Applications

TERNALLOY 402 is a low melting Silver brazing filler metal (very similar to TERNALLOY 40) with the addition of Silicon (0,15%-0,2% in weight). It has a relatively narrower melting range than other cadmium-free classifications with similar silver content. It has an excellent characteristics and very good filler forming quality. Suggested parent metal: copper and copper alloys and any steels and stainless steels. TERNALLOY 402 is suggested for the application where the capillarity attraction into the joint is more important than the resistance to mechanical stress! Typical applications are in refrigeration and air conditioning, where the parent metal can accept its working temperature. Suitable to manual or machine feeding.

Suggested Flux

F62 / F16

Base Metals

Any steel, copper and copper alloys, nickel and nickel alloys

Heat Sources

Flame/Induction

Bare rods	Fluxcoated	Wire < Ø 1,0	Wire > Ø 1,0	Foil	Preforms	Paste
X	-	-	X	-	0	-

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